CEWELD®

AlMg 3 Tig

CATEGORY	GMAW-GTAW Solid wires
TYPE	Tig filler metal for welding Aluminium Magnesium alloys.
APPLICATIONS	Suitable for base metals with maximum 3% Mg. These alloys are suitable for a big range of applications in the construction sector, in general, and in the structural industry. Widely used in ship and vessel building.
PROPERTIES	This alloy offers excelent weldabillity when properly cleaned prior to welding. Heavy parts and thicker plates should be preheated (150°C), prior to welding The alloy shows good corrosion-resistance and an excellent colour-uniformity after anodizing. AlMg3 offers also good resistance against seawater.
CLASSIFICATION	AWS A 5.10: ER 5654 EN ISO 18273: S Al 5754-AlMg3 DIN: W.Nr. 3.3536 DIN 1732: SG-AlMg3
SUITABLE FOR	Aluminium alloys: AlMg Mn, AlMg 3Mn, AlMg1, AlMg2, AlMg2,7Mn, AlMg3, AlMg3,5, AlMgSi0,5, AlMgSi0,8, G-AlMg3Si, 3.3315, 3.3535, 3.3206, 3.3541, EN AW 5005A, EN AW 5754, EN AW 6060, EN AC 51100, EN AW 5454, EN AW 5251
APPROVALS	CE approved
WELDING POSITIONS:	

ALL WELD DEPOSIT (WEIGHT %)

Al	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	others
Rem	<0.4	<0.4	<0.1	<0.5	2.6-3.6	<0.3	<0.2	<0.15	<0.15

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc / HV
AW	>80	>190	>20				

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters		Packing (kg)	
D (mm)	Current (A) AC	single	master
1,6 x 1000	25-50	5	20
2.0 x 1000	40-75	5	20
2.4 x 1000	90-130	5	20
3.2 x 1000	160-240	5	20
4.0 x 1000	290-340	5	20

REDRYING TEMPERATURE	not required
GAS ACC. EN ISO 14175:	I1, I3